

Work Order ID 50763

July 21, 2009 2:40:14 PM



Page 1

Item ID: D2596

Accept



Setup Start



Revision ID: D

Stop



Item Name: Web, 205 Skidtube

Start Date: 07/22/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *MF*

Date: 09-07-21 Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2596 | Rev D |

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5" 12- Use Jig DT8093 to drill pilot holes
#30 13- Open to 0.630" diameter as per Dwg D2596 14- Deburr

10 \emptyset BE 09/07/30

110

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

10 \emptyset AWM 9-7-31

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) S 09/07/31

(10) \emptyset

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 50763

July 21, 2009 2:40:14 PM

Page 2

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Accept

Revision ID: D

Item Name: Web, 205 Skidtube

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Required Date: 07/31/2009 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: L-6

0.00



Packaging

Memo

0.00

Packaging

10 ϕ - ANM9-7-31

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

209-0805

12

31-07-09

✓ 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Page 1

July 21, 2009 2:40:14 PM

Work Order ID: 50763



Parent Item: D2596RevD



Parent Item Name: Web, 205 Skidtube



Start Date: 07/22/2009

Required Date: 07/31/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|----------------------------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|------------------------------------------------------------------------------------------------|---------------|----------------|--------|
| D2500-3-100RevU/R  Ext'n - I' Beam Web 4" | | Manufactured | No | | | 100 | Each | 0.0000 | 10.0000  | 340196 10R | BE 09/09/30 | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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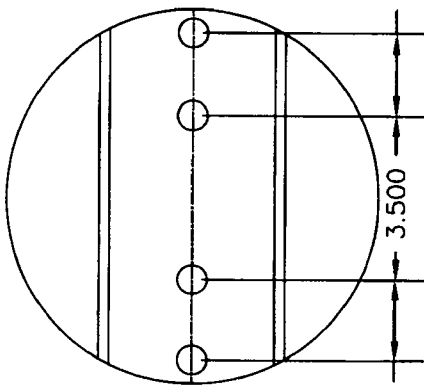
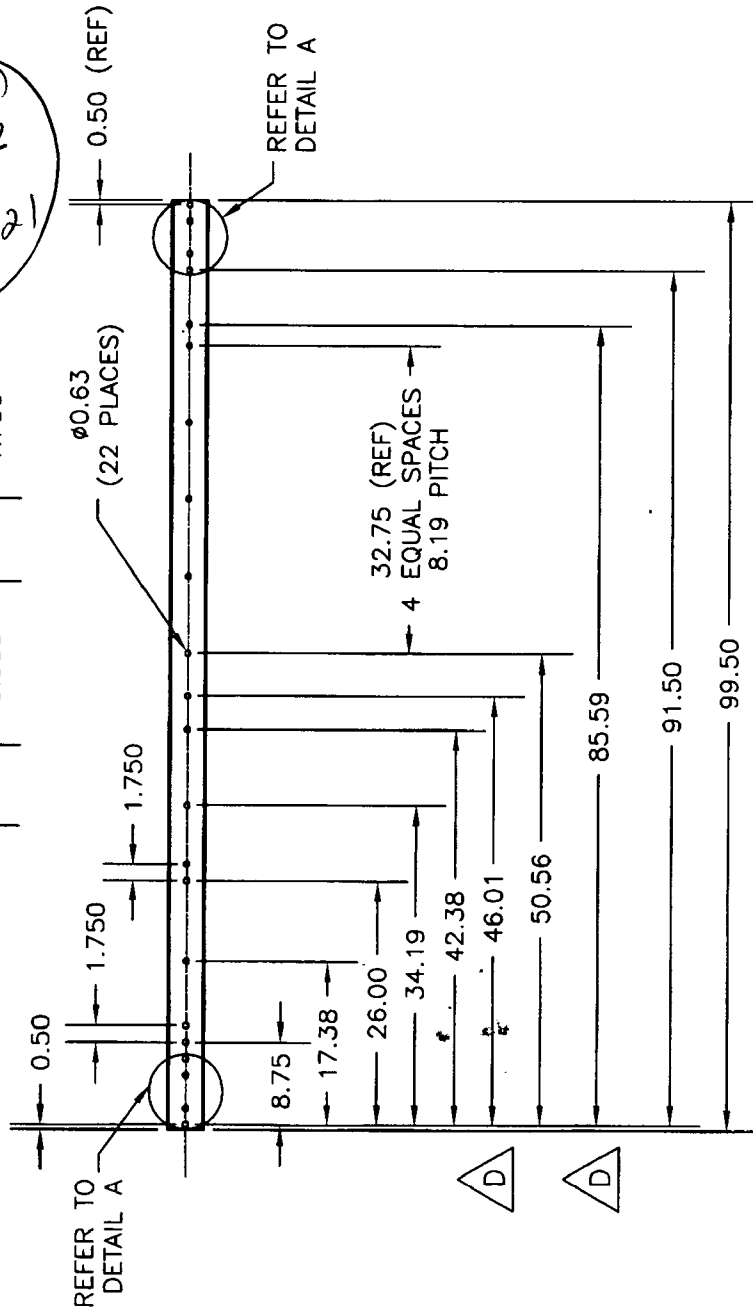
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NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN <i>RH</i> | DRAWN BY <i>PH</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2596 | REV. D SHEET 1 OF 1 |
| DATE 07.04.17 | TITLE 205 WEB | | SCALE 1:20 |
| A | 96.09.16 | NEW ISSUE | |
| B | 97.07.23 | Ø0.63 HOLE WAS Ø0.56 | |
| C | 98.09.14 | INCORPORATED DEO 9097 | |
| D | 07.04.17 | INCORPORATED DEO 9183 | |

RELEASED
07.06.18SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *50763*
mf
09-07-21**DETAIL A**
SCALE 1:4**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

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